

Work Order ID 82352

March-29-12 2:31:34 PM

82352

Page 1

Item ID: D3339-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Wearpad Center
 Start Date: 29/03/2012 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 12/04/2012 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3339	Rev <i>X</i>								
100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3339								
1010 .063	Dwg Rev: <i>B</i>								
	Prog Rev: <i>B</i>								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									

12 *0* *Jm*
12-5-22

12 *0* *Jm*
12-5-22

12 *0* *Jm*
12-5-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Item ID: D3339-3

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Wearpad Center

Start Date: 29/03/2012 Start Qty: 12.00

12

Cust Item ID:

Required Date: 12/04/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

0.00

130

Brake NC

NC BRAKE

Memo

0.00

Brake NC

1-Debur if necessary

2-Form as per Dwg D3339 using DT8326 and DT8261

140

0.00

140

QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

150

0.00

150

Large Fab

Large Fab

Memo

0.00

Large Fab

1-Weld Hard coat 7560 per Dwg D3339, use DT8210 & DT8810 Layout Jig

A/R 7560 Hardcoat

Batch: m/21603 -> 228

(12)

S
12/05/23

12

W 12-05-23

(x12)

m-l

12-06-04

W/O:		WORK ORDER CHANGES						
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00							<i>DL</i>
170 *170* Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 Memo START TIME: <i>2:30</i> OVEN TEMPERATURE: <i>320°F</i> FINISH TIME: <i>3:00</i>	0.00 0.00							<i>MT</i> <i>12x</i> <i>12/06/04</i>
180 *180* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							<i>12x</i> <i>12/06/04</i>

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

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Accept

N900040100

Setup Start ***NS1***

Stop *NS2*

Start Date: 29/03/2012 **Start Qty:** 12.00

12

Cust Item ID:

Required Date: 12/04/2012 **Req'd Qty:** 12.00

12

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp

190

Identify as per dwg & Stock Location: 56/97A 0.00

190

Packaging

Memo

0.00

Packaging

200

QC21- Final Inspection - Work Order Release

0.00

200

QC

Memo

0,00

Quality Control

12

Sae 12/06/05

12/6/59

ME
12-06-05

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NOTE: Date & initial all entries

Picklist Print

March-29-12 2:31:38 PM

Page 1

Work Order ID: 82352

82352

Parent Item: D3339-3

D3339-3

Parent Item Name: Wearpad Center

Start Date: 29/03/2012

Required Date: 12/04/2012

Start Qty: 12.00

Required Qty: 12.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M1010S16GA		Purchased	No				sf	165.0000		1.2			

M1010S16GA

**

1010/1025 sheet 16GA

Location

Loc Qty

Loc Code

MAT019

165

116791

21.4

117500

17.6

118965

30

121195

96

116791

SM
12-5-22

W/O:		WORK ORDER CHANGES					
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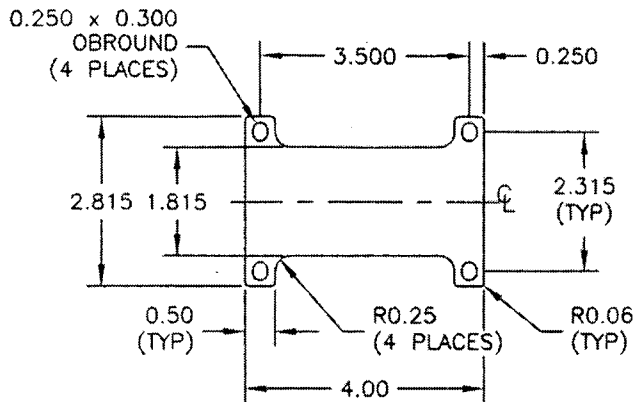
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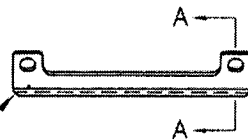
NOTE: Date & initial all entries

DART**RELEASED**
05.11.22

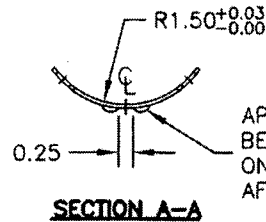
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3339	REV. B SHEET 1 OF 3
DATE 05.11.22		TITLE REPLACEMENT WEARPAD	SCALE 1:3
A	05.06.06	NEW ISSUE	
B	05.11.22	CORRECTED HOLE SPACING D3339-7F	

**D3339-1F FLAT PATTERN**

APPLY 7560
HARDCOAT WELD BEADS
PER DT3339-3T1
AFTER FORMING
(SEE SECTION A-A)

**D3339-3 CENTER WEARPAD**
(MADE FROM D3339-1F)**D3339-1F/-3/-5 WEARPAD****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR
CSA G40-21, 38W/44W/50W/60W/70W SERIES
COLD ROLLED STEEL 16 GAUGE (0.060 THICK)
- 2) PART IS SYMETRICAL ABOUT CENTER LINE
- 3) WELD PER DART QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP CORNERS 0.063 MAX

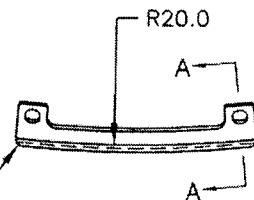


APPLY 7560 HARDCOAT WELD
BEADS, 0.063 TO 0.125 THICK,
ON BOTTOM SURFACE
AFTER FORMING

SECTION A-A

NO. 82352
12/03/29
WORK ORDER
WITHOUT NOTICE
SUBJECT TO AMENDMENT
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY

APPLY 7560
HARDCOAT WELD BEADS
PER DT3339-5T1
AFTER FORMING
(SEE SECTION A-A)

**D3339-5 FORWARD WEARPAD**
(MADE FROM D3339-1F)**Copyright © 2005 by DART AEROSPACE LTD**

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

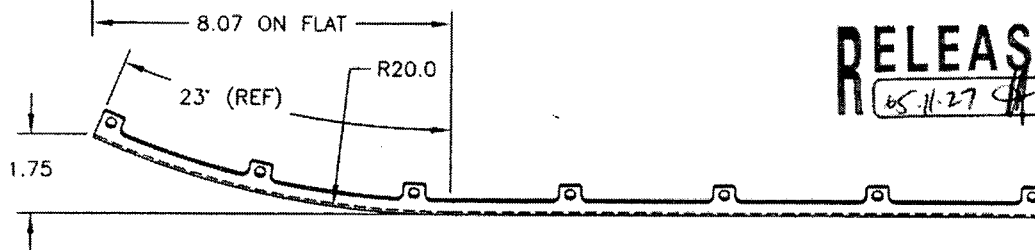
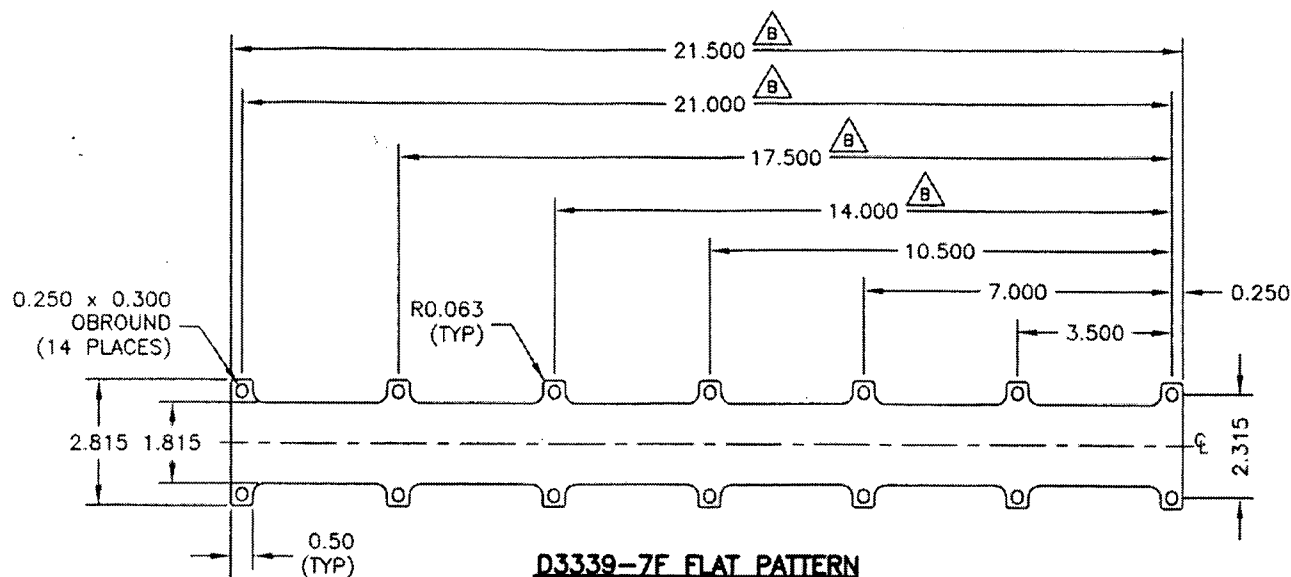
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries



DESIGN MB	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3339	REV. B SHEET 2 OF 3
DATE 05.11.22		TITLE REPLACEMENT WEARPAD	SCALE 1:4



RELEASED
65-11-27

APPLY 7560 HARDCOAT
WELD BEADS PER DT3339-7T1
AFTER FORMING
(SEE SECTION A-A)

D3339-7 LONG FORWARD WEARPAD

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR
CSA G40-21, 38W/44W/50W/60W/70W SERIES
COLD ROLLED STEEL 16 GAUGE (0.060 THICK)
- 2) PART IS SYMMETRICAL ABOUT CENTER LINE
- 3) WELD PER DART QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP CORNERS 0.063 MAX

02352

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

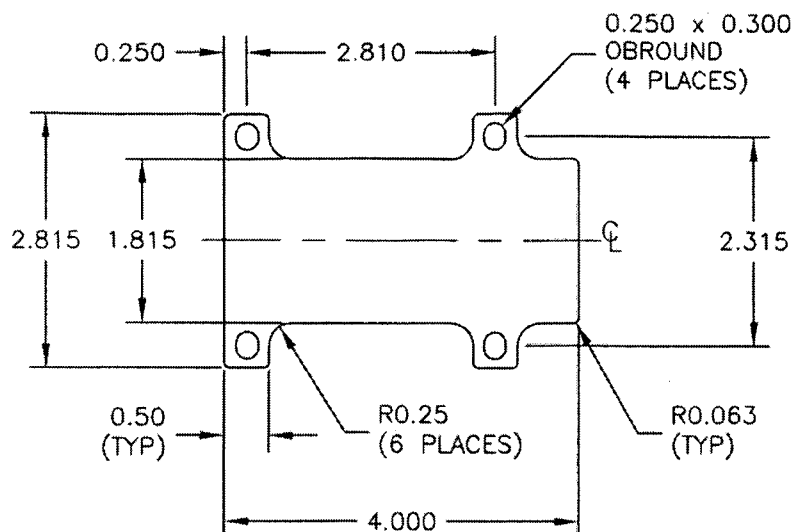
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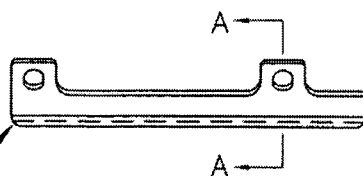
NOTE: Date & initial all entries

DART

DESIGN MB	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3339	REV. B SHEET 3 OF 3
DATE 05.11.22		TITLE REPLACEMENT WEARPAD	SCALE 1:2

**D3339-9F FLAT PATTERN****RELEASED**
05.11.22 #

APPLY 7560
HARDCOAT WELD BEADS
PER DT3339-9T1
AFTER FORMING
(SEE SECTION A-A)

**D3339-9 AFT WEARPAD****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES COLD ROLLED STEEL 16 GAUGE (0.060 THICK)
- 2) PART IS SYMETRICAL ABOUT CENTER LINE
- 3) WELD PER DART QSI 004
- 4) FINISH: POWDER COAT GREY SANTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP CORNERS 0.063 MAX

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